

Work Order ID 69187 -3

Wednesday, May 04, 2011 11:17:53 AM

Page 1

Item ID: D3494-1

Revision ID:

Item Name: Stub Cover

Start Date: 5/4/2011 Start Qty: 13.00

Required Date: 5/5/2011 Req'd Qty: 13.00

Reference:

Approvals: Process Plan: *11*

QC:

Date: 11054

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3494

Rev D

100

0.00



Waterjet

FLOW CNC Waterjet

304.063

Memo

1-Cut as per Dwg

Dwg Rev: *B*

Prog Rev: *D*

2-Deburr if necessary

0.00

B11-5-4



110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

B11-5-4

Work Order ID 69187

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Page 2

Item ID: D3494-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Stub Cover

Start Date: 5/4/2011 Start Qty: 13.00



Cust Item ID:

Required Date: 5/5/2011 Req'd Qty: 13.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120



QC

Quality Control

QC8- Inspect parts - second check

0.00

0.00

Memo

Sub 105104

14

130



Brake NC

Brake NC

Bend as per dwg

0.00

0.00

Memo

Sub 105111

14

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

Memo

Sub 105111

14

Work Order ID 69187

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Item ID: D3494-1

Accept



Setup Start



Revision ID:

Item Name: Stub Cover

Stop



Start Date: 5/4/2011 Start Qty: 13.00



Cust Item ID:

Required Date: 5/5/2011 Req'd Qty: 13.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

144

Weld per dwg A/R S.S. rod Batch: M117659

0.00



Large Fab

Memo

0.00

Large Fab

1- WELD
2- GRIND AS PER DWG

12

01-07-11 JB6/EZ

146

QC10- Inspect visual per QS1004- ground welds

0.00



QC

Memo

0.00

Quality Control

Suzuki

147

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Suzuki

(x12)

Work Order ID 69187

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Page 4

Item ID: D3494-1

Revision ID:

Item Name: Stub Cover

Start Date: 5/4/2011 Start Qty: 13.00

Required Date: 5/5/2011 Req'd Qty: 13.00

Reference:

Approvals: Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start

Stop

Sequence ID/
Work Center ID

150



Powdercoat

Powder Coating

M115128

Operation
Description

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

Memo

Set Up/
Run Hours

0.00

0.00

0.00

0.00

0.00

0.00

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Start Time: 9:00
Temp: 320°F
Finish Time: 9:30

12xφ M/L 11/07/12

12 φ J/L 11/07/12

11/7/12 S/P 12

160



QC

Quality Control

QC3- Inspect Part Finish

Memo

170



Packaging

Packaging

Identify as per dwg & Stock Location: 225

Memo

Work Order ID 69187

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Page 5

Item ID: D3494-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Stub Cover

Start Date: 5/4/2011 Start Qty: 13.00



Cust Item ID:

Required Date: 5/5/2011 Req'd Qty: 13.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/7/13
ME
11-07-13

Picklist Print

Wednesday, May 04, 2011 11:17:59 AM

Page 1

Work Order ID: 69187

Parent Item: D3494-1

Parent Item Name: Stub Cover



Start Date: 5/4/2011

Start Qty: 13.00

Required Date: 5/5/2011

Required Qty: 13.00

Comments: IPP Rev:A New Issue 06-05-18 JLM
 IPP rev B ecn 888 06.12.13 EC
 add welding DD 10.03.03 verifie by:EC
 chg design EC verified by:DD

IPP Rev:C
 Ipp RevD ECN 10-555

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S16GA



304/316 Sheet .063

Purchased

No

100

sf

108.5000

0.72

9.852632



AB11-5-4

Location

MAT020

117275

Loc Qty

108.5

108.5

Loc Code

117275

(14)

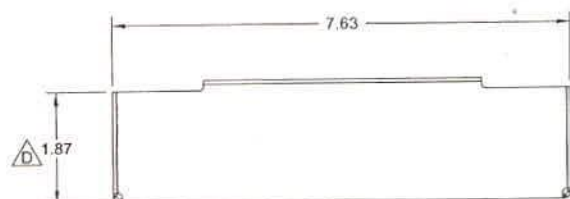
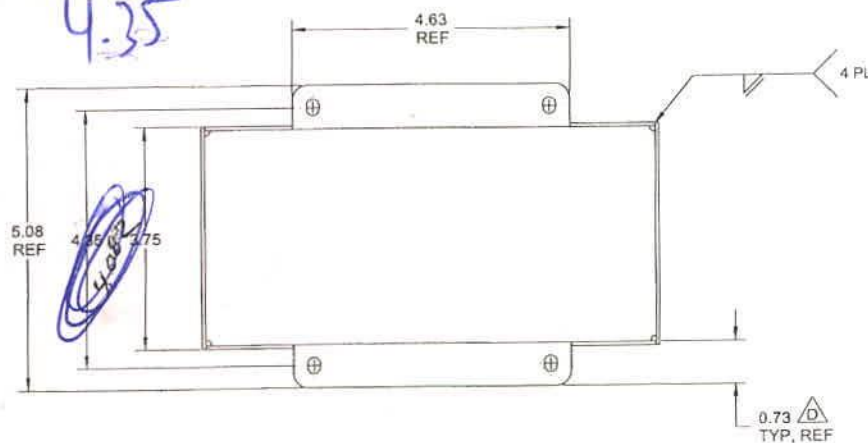
DART AEROSPACE LTD		Work Order:	69187
Description: Stub Cover		Part Number:	D3494-1
Inspection Dwg: D3494	Rev: D	Page 1 of 1	

☒ **First Article** ☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.18	+/-0.010	0.209	x		V B02	
0.368	+/-0.010	0.368	x		V	
0.766	+/-0.010	0.767	x		V	
2.508	+/-0.010	2.529	x		V	
6.278	+/-0.010	6.276	x		V	
8.039	+/-0.010	8.037	x		V	
8.437	+/-0.010	8.440	x		PROW502	
8.805	+/-0.010	8.814	x		P	
1.832	+/-0.010	1.827	x		V	
3.262	+/-0.010	3.255	x		V	
3.604	+/-0.010	3.601	x		V	
3.940	+/-0.010	3.940	x		V	
7.544	+/-0.010	7.544	x		V	
7.881	+/-0.010	7.881	x		V	
9.317	+/-0.010	9.320	x		P	
11.148	+/-0.010	11.155	x		P	
0.060	+/-0.010	0.058	x		V	

Measured by: B	Audited by: S	Preliminary Approval:
Date: 11-5-24	Date: 11/05/24	Date:

Rev	Date	Change	Revised by	Approved
A	08.02.28	New Issue	KJ/DD	
B	10.02.18	Dimensions updated per Dwg Rev C	KJ	
C	11.04.28	Dimensions updated per Dwg Rev D	KJ	

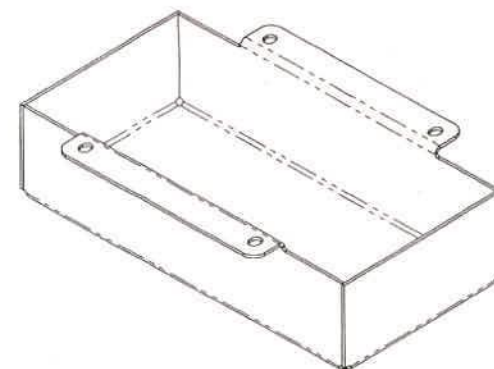


D3494-1 STUB COVER

NOTES:

- 1) MATERIAL: MAKE FROM D3494-1F
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 01 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3494-1" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 1.29 lbs
- 8) WELD PER DART QSI 004

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENTS
WITHOUT NOTICE
WORK ORDER
NO. 69187 11-05-1



RELEASED
2010-04-26

D	TOLERANCE WAS 3 DEC. PLACES (ZN B5-1); 1.87 WAS 1.86 (ZN B8-1); 2.04 WAS 2.00 (ZN B3-1); REVISED D3494-1F (ZN A6-2); CORRECTED WEIGHT INFO (ZN A8-1); UPDATED MATERIAL (ZN A8-2); REASON: SEE NCR#10-037.	MB	10.04.15
C	DRAWING TRANSFERRED TO "B" SIZE. GENERAL REVISION TO FLAT PATTERN SEE PREVIOUS REV FOR DETAILS. C8-1 DIM 5.08 WAS 5.05 AND WAS A "HARD CALLOUT". C5-1 0.87 DIM WAS 0.85; B6-1 1.95 DIM WAS 1.86 B3-1 & 2.04 DIM WAS 2.00. REFER TO PAR 08-003 FOR FURTHER DETAILS.	AJS	08.10.31
B	REVISED FLAT PATTERN, BENDING DIMENSIONS, Ø0.208 X 0.268 SLOTS WERE Ø0.208 HOLES.	MB	06.11.28
A	NEW ISSUE	MB	06.01.18
REV.	DESCRIPTION	BY	DATE
DESIGN	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3494 STUB COVER <small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY INFORMATION. IT IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>		
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.04.15	REV. D SHEET 1 OF 2 SCALE NTS	

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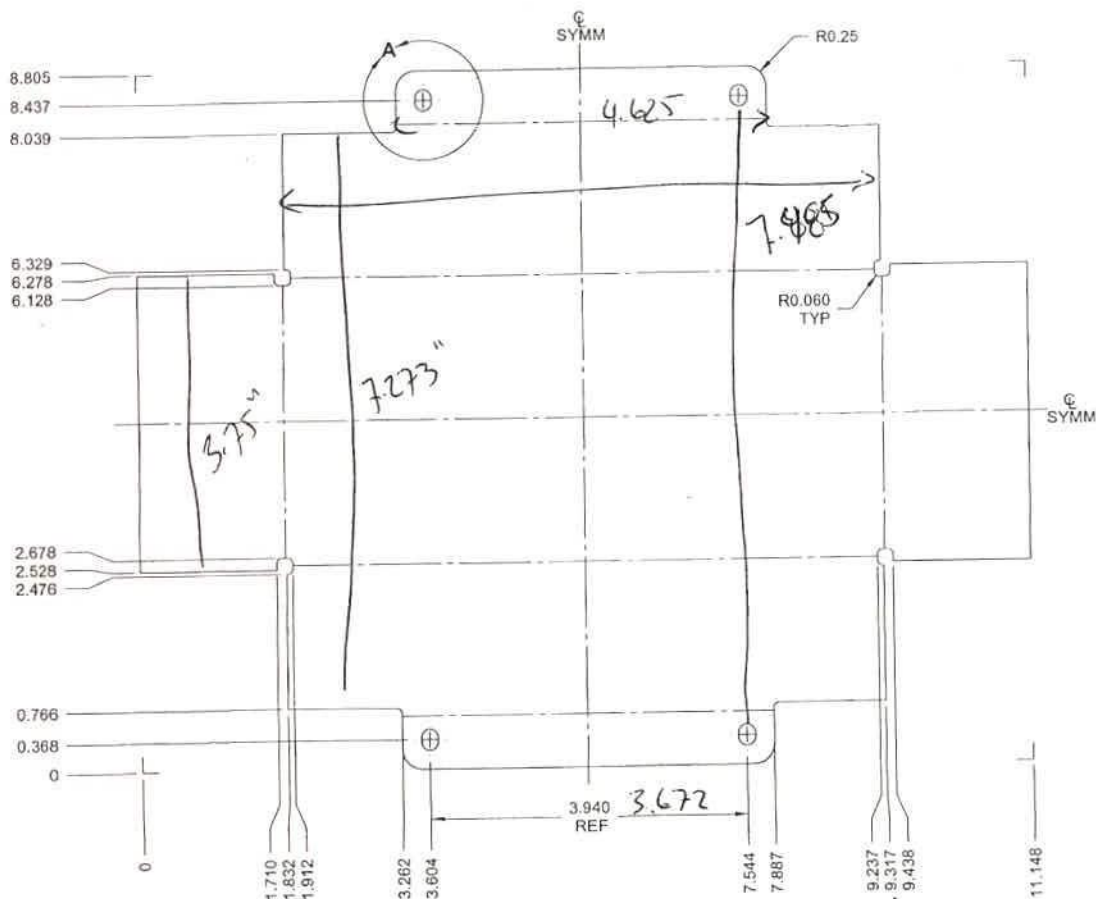
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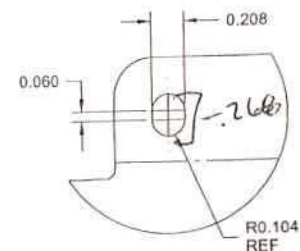
1

D
C
B
A

D3494-1F STUB COVER FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, 16 GAUGE (0.060 THICK)
PER AMS 5513 (304) OR 5524 (316) OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART C. 118 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE COMPLETED PART WEIGHT



DETAIL A
SLOT DETAIL 4 PL
SCALE 2X

RELEASED
2010-04-26
MP

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3494	REV. D
MFG. APPR.			SHEET 2 OF 2
APPROVED		TITLE STUB COVER	SCALE NTS
DE APPR.			
DATE	10.04.15		

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